

Work Order ID 67263

Monday, March 14, 2011 11:00:03 AM

BLUE



Page 1

Item ID: D2651-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 3/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 11/03/14 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00

11.3.29

100



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D2651 2- Deburr

110

0.00

11.3.29

100



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

11/3/29

100



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Small Fab | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Deburr ias per dwg D2651 | 0.00 | | | | | | | |
| | | | | | | | | | |
| 140 HandFinish | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | |
| | | | | | | | | | |
| 155 SprayPaint | Spray Painting per QSI005 4.2 | 0.00 | | | | | | | |
| Spray Painting | Memo | 0.00 | | | | | | | |
| | Spray Painting: prime grey B: 117319 spray paint delfleet blue B: 115985 clear delfleet B: 117113 | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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Page 3

Monday, March 14, 2011 11:00:03 AM

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Revision ID:

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Item Name: Plug

Start Date: 3/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 QC3- Inspect Part Finish

0.00



QC14

QC Memo

0.00

Quality Control

1 11-04-28

170 Identify as per dwg & Stock Location: FP-1A

0.00



Packaging Memo

0.00

Packaging

100 11-04-28

180 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/4/28

mtf 11-04-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 11:00:00 AM

Page 1

Work Order ID: 67263



Parent Item: D2651-1



Parent Item Name: Plug

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A ☐ 02.04.15 ☐ New Issue ☐ NG ☐
IPP: B ☐ 05.12.12 ☐ added deburr EC ☐

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6R0.500

Purchased

No

100

f

17.8850

0.0401

4.221053



ml 11.3.29

6061-T6 Round Bar .500"

Location

Loc Qty

Loc Code

MAT

17.885

114488

17.885

4.475

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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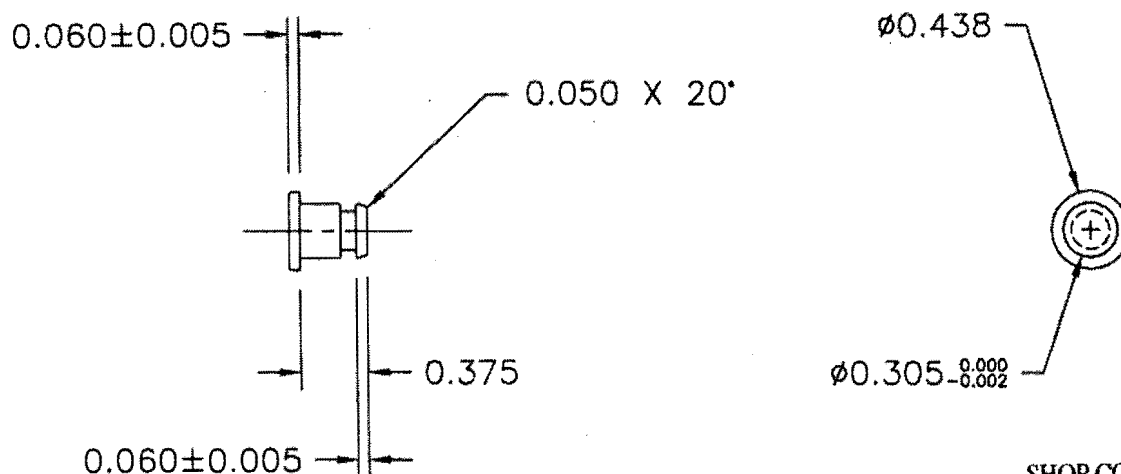
NOTE: Date & initial all entries



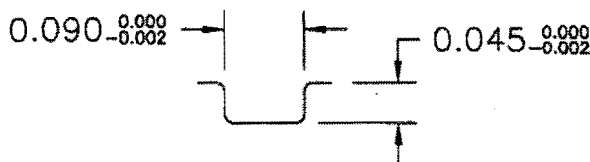
| | | | |
|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2651 | REV. B SHEET 1 OF 1 |
| DATE 03.12.19 | | TITLE PLUG | SCALE 1:1 |
| A | 97.03.25 | NEW ISSUE | |
| B | 03.12.19 | ADD POWDER COAT, MS28775-008 | |

RELEASED
03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 67263
CZ11/03/H

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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